

Date:  
User:Monday, 22/09/2008 2:20:13 PM  
Julie Gecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARING ASSEMBLY  
 Job Number : 42177 - 2  
 Estimate Number : 10716  
 P.O. Number :  
 This Issue : 22/09/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 22/09/2008 Type : MACHINED PARTS  
 Previous Run : 40352  
 Written By :  
 Checked & Approved By : JUO 08.9.22  
 Comment : Est Rev:A 04.02.18 New issue KJ/DS  
 Est Rev:B ECN 1060 07-11-12 DD verified by:EC

Part Number : D3121241  
 Drawing Number : D3121 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 29/09/2008 Qty: 17 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDLRINR12500 DELRIN ROUND BAR 1.25"



No material SA 08/10/18



Comment: Qty.: 0.0546 f(s)/Unit Total: 13.6500 f(s)

Material: ~~01-25~~ Delrin Rod

(M-DELRIN-R1.2500) Identify as D3121-25

Batch: M108460 10A + 3A

Ø 1.500

MIC 761 3A

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

SA 08/10/18

308

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/10/18

308

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/10/20

308

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 250.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

42410 100 X

42200 190 X

B43550 (17X)

08/11/20 (17)

08/10/20 (290)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 42177

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 238

AS 08/11/27

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/03

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-12-03

Job Completion





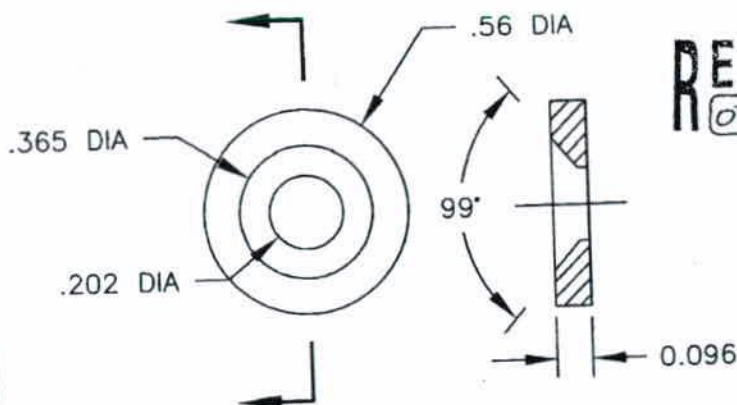




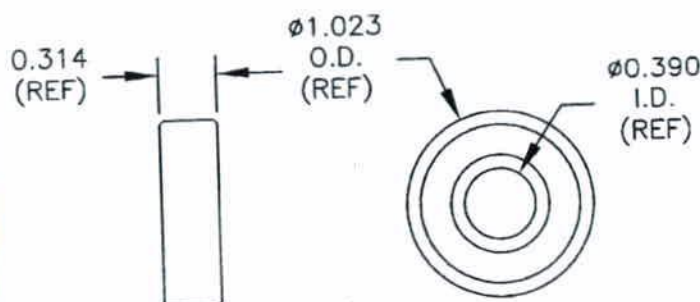


**DART**

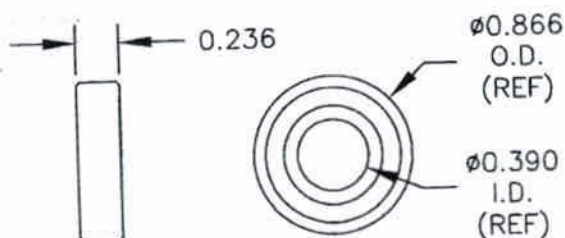
DESIGN #	DRAWN BY LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY SCALE 1:1	

**D3121-17 WASHER (SCALE 2:1)**

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

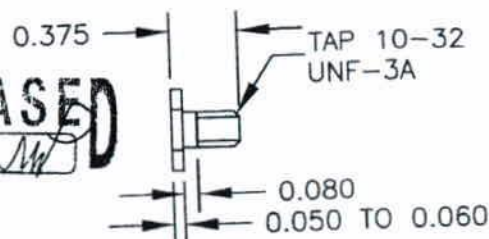
**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

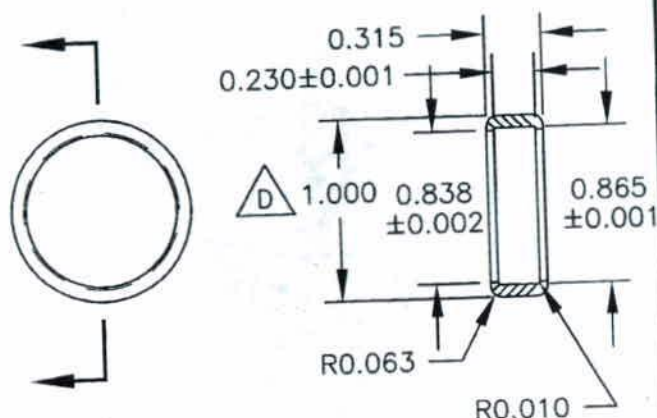
**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.11.07

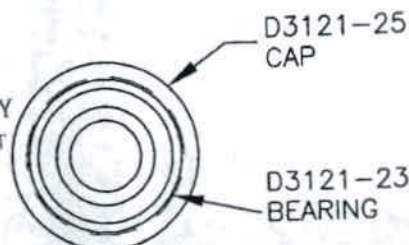
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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WORK ORDER  
NO. 4217

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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